

Date: Tuesday, 1/3/2006 4:20:42 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LUG BRACKET
Job Number :	25383		
Estimate Number :	10364		
P.O. Number :	N/A	Part Number :	D3046041
This Issue :	1/3/2006	Drawing Number :	D3046 REV. A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	A
Previous Run :	N/A	Material :	N/A
	Type :	Due Date :	1/10/2006
	SMALL /MED FAB	Qty:	4 Um: Each
Written By :	See comment below		
Checked & Approved By :	See comment below		
Comment :	Est: A 01.08.27 New issue SM/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D30461	Lug Bracket
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	B24715

2.0	D30463	Lug Bracket
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

LUG BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3046-3 (Bell P/N: 206-052-106-1)	Lug Bracket	N/A

Return Authorization #

Bell original batch#

443

551749-24/550928.24

see w/o 25385

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Transfer drill holes from D3046-3 into D3046-1 as per Dwg D3046
- 2- Counter sink inside holes of D3046-1 as per Dwg D3046
- 3- Deburr

SD 06/01/09

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0601.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:20:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 25383

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

B 8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

ml 06 01 09

H 7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06-01-09

7.0

MS20426AD57

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet

Qty Part Number

Description

Batch

10

MS20426AD5-7

Rivet

13876

SB 06/01/09

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

SB 06/01/09

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-09

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

ml 06 01 10

4

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/01/10

(4) C2

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

06/01/10

(4)

06/01/10

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/01/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:20:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 25383

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06-01-10 (4)

Job Completion



W 06-01-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

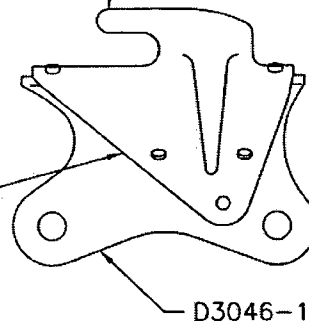
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
#		KF		HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. A
01.08.23		01.08.23		D3046	SHEET 1 OF 2
DATE		TITLE		LUG BRACKET	SCALE
A		NEW ISSUE			1:2

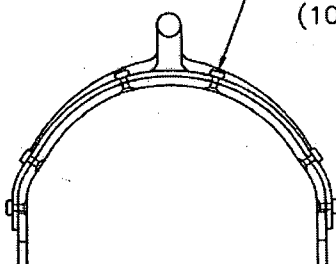
D3046-3
(BELL P/N 206-052-106-1)



D3046-1

CENTER D3046-3
ON D3046-1

TRANSFER DRILL $\varnothing 0.156$ HOLES
FROM D3046-3 TO D3046-1.
C'SINK $\varnothing 0.286 \times 100^\circ$
D3046-1 INSIDE BORE.
ASSEMBLE USING MS20426AD5-7
RIVETS.
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

NOTES:

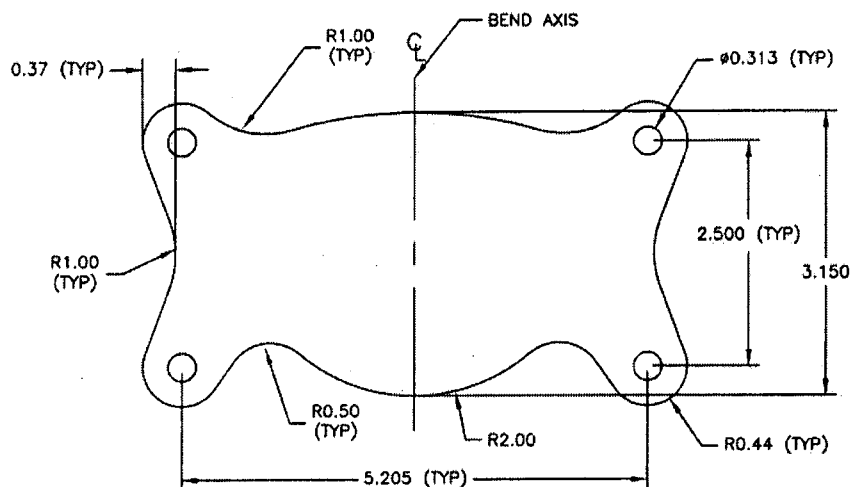
- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

RELEASED
01.08.23

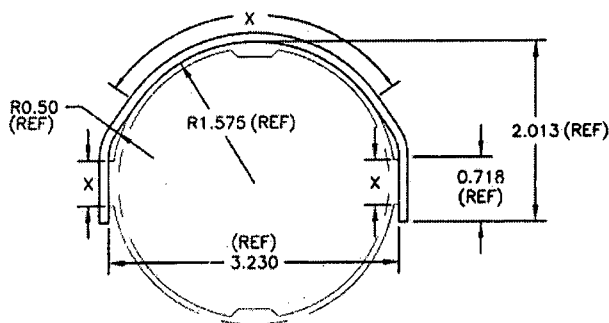
CONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITH OUT NOTICE
WORK ORDER
NO 25383



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (C)



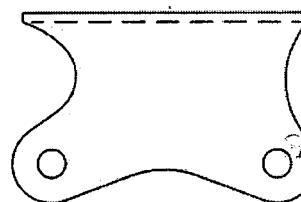
D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



NOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT PERMISSION

WORK ORDER
NO. 25383

RELEASED
01.08.23

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Linda Lacelle

From: Holly Menard [hmenard@dartaero.com]
Sent: Tuesday, January 03, 2006 10:42 AM
To: 'Linda Lacelle'
Cc: Peggy Macdonald; 'Heather Mahon'
Subject: RE: DSI 9213

Spoke with Don Brooks the Lugs were shipped from his location. He can not confirm as to which courier was used or whether they were shipped on Thursday or Friday. However they are currently on their way to us.

Holly Menard
Sales Associate
DART Helicopter Services, LLC
Tel: 1.613.632.3336
1.800.556.4166
Fax: 1.613.632.4443
hmenard@dartaero.com
www.darthelicopterservices.com <<http://www.darthelicopterservices.com>>
"we're more than just skidtubes"

-----Original Message-----

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, January 03, 2006 9:14 AM
To: *Peggy McDonald (E-mail); Heather Mahon (E-mail); Holly Menard (E-mail)
Subject: DSI 9213

Do any of you know when we will be receiving the parts back from the customer to make these?
LL